

Date Thursday, 16/08/2007 11:32:37 AM  
 User Linda Lacelle

## Process Sheet

*Split*

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	STEP WELDMENT
Job Number	:	34026	Part Number	:	D3562041
Estimate Number	:	12576	Drawing Number	:	D3562 UNDER REVIEW
P.C. Number	:	N/A	Project Number	:	N/A
This Issue	:	16/08/2007	Drawing Revision	:	A
Prsht Rev.	:	NC	Material	:	N/A
First Issue	:	<i>N/A</i>	Due Date	:	09/09/2007
Previous Run	:	33579	Qty:		5
Written By	:		Um:		Each
Checked & Approved By	:				
Comment	:	Est Rev:A	New Issue	06-11-09	JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion	<i>34014</i>
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Check Material for any Dents or Defects

*a.m 07.10.04*

*6*

2.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>334185</i>



*07.10.04*

*5*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562 *a.m 07.10.04*

*5*

2-Deburr and bevel ends for welding *a.m 07.10.04*

*6*

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

*updated on ECN 987 by RL*

4-Grind end cap welds flush as per Dwg D3562

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/00							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:37 AM  
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Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC5 INSPECT WORK TO CURRENT STEP



*2/10/16*



Comment: INSPECT WORK TO CURRENT STEP

5.0 QC9 VISUAL WELDING INSPECTION



*11/10/16*



Comment: VISUAL WELDING INSPECTION

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*07.10.06*

*5*

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D3560041 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

*B 34474*

*a.m 07.10.11*

*5*

9.0 D3560043 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: *B 34474*

*a.m 07.10.11*

*5*

10.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)

Blind Rivet

batch: *M105 125*

*a.m 07.10.11*

*5*

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.

Touch-up rivet holes with alodine as per dwg d3562

*a.m 07.10.11*

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:37 AM  
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Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: M104677

*AM 07.10.11 (5)*

12.0 QC5

INSPECT WORK TO CURRENT STEP



*Sc 07/10/15 (5)  
TEST PT*



Comment: INSPECT WORK TO CURRENT STEP

13.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M03794

*AM 07.10.16 (5)*

2-Grind end cap welds flush as per Dwg D3562

*AM 07.10.16*

*5*

14.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*AM 07.10.16 (5)*

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sc 07/10/16 (5)*

16.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M-8 07/10/17*

*(5x)*

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105694

*FL 07/10/18 (5)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	M	Split up		W. O. 00014				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-24

19.0 D2808

Spacer



MF  
07-10-24

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

B32752 x 7mx, #3mx B32816

20.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



07/10/24

Comment: SMALL & MEDIUM FAB RESOURCE 1

MF 07-10-24

21.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/24 (X8)

22.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07/10/24

07/10/24 (8)

23.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/24 (5)

Job Completion



07/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

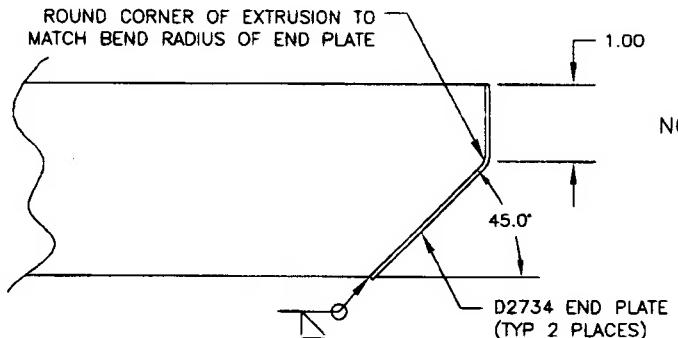
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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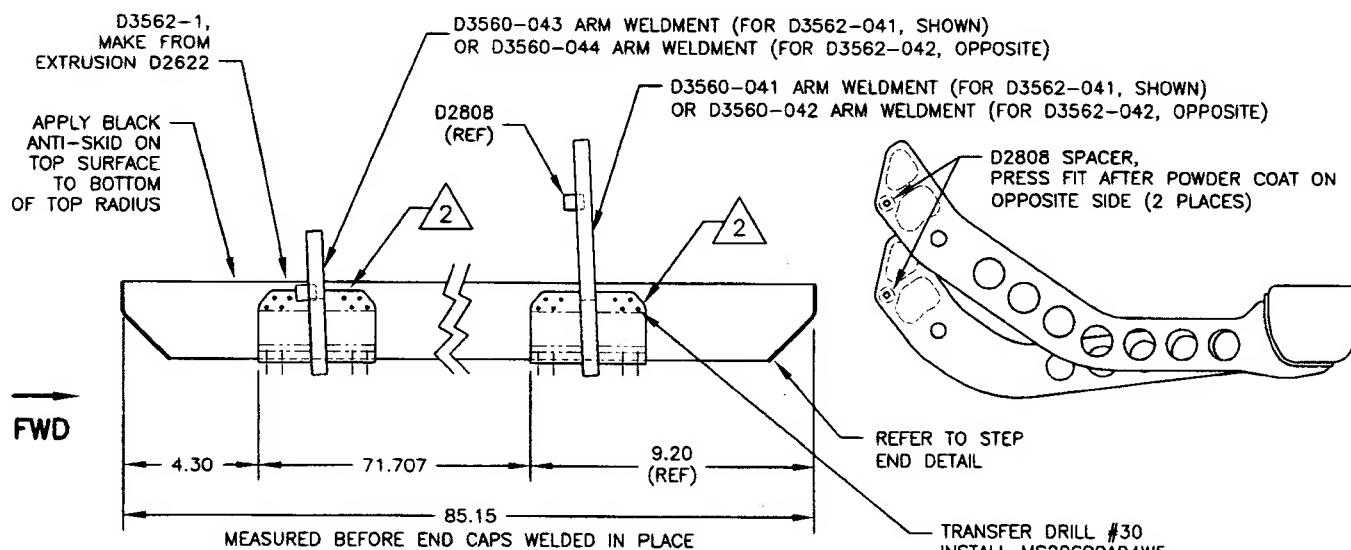
**RELEASED**  
07.06.29



DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
		REV. C
		SHEET 1 OF 1
DATE		SCALE
07.06.19		NTS
A	06.09.26	TITLE
B	07.01.15	STEP ASSEMBLY
C	07.06.19	DRAWING NO.
		D3562



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



#### D3562-041 LH STEP ASSEMBLY (SHOWN)

#### D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES